

Work Order ID 63582

Thursday, November 04, 2010 1:09:28 PM

Page 1

Item ID: D2939-1

Accept

Revision ID:

Item Name: Saddle LH In, 206

Start Date: 11/4/2010 Start Qty: 6.00

Required Date: 11/12/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: *H*Date: *10-11-04* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

ack 10/11/25

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

6 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

ack 10/11/25

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

6 0

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

ack 10/11/25

Quality Control

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Work Order ID 63582

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Page 3

Item ID: D2939-1

Accept

Revision ID:

Item Name: Saddle LH In, 206

Start Date: 11/4/2010 Start Qty: 6.00

Required Date: 11/12/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 428A

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



=> JH 10/11/29

y6

0

10/11/29 6

CK 10/11/30 JH
ME
10-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 1:09:32 PM

Page 1

Work Order ID: 63582

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	2.0000	1	6			

Saddle Billet

Location

Loc Qty

Loc Code

MAT40

2

61385

2

B 63537 XL

mk 10/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43582
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.114	.111	.113	Vern	ML-7
B	0.100	0.140		.115	.117	.115	.116		
C	0.100	0.140		.121	.126	.120	.116		
D	0.210	0.230		.220	.221	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.260	.260	.260	.260		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.236	.236	.236	.236		
N	0.100	0.140		.112	.113	.112	.112	Mic	ML-01
O	0.540	0.560		.551	.549	.550	.549	Vern	ML-7
P	0.490	0.510		.500	.501	.501	.501		
Q	3.715	3.725		3.718	3.718	3.748	3.748		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.257	.250	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		.317	.317	.317	.317		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.573	1.573	1.573	1.574		
Z	0.178	0.198		.188	.188	.188	.188	Rul-gage	REF
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Amf
Date:	10/11/25

Audited by:	H.A
Date:	10/11/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD	Work Order: 43582
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

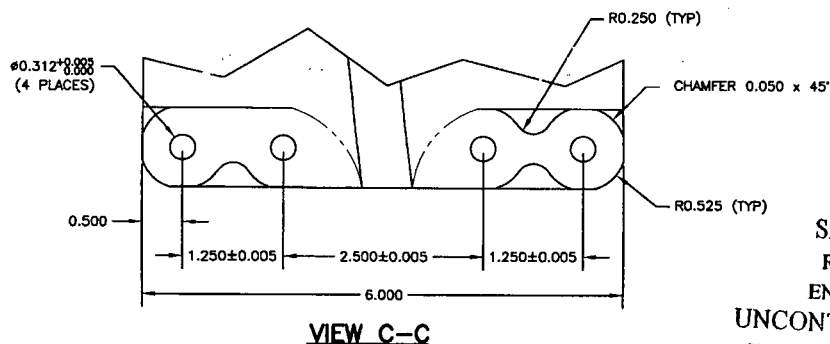
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.113			Ucrn	ML-7
B	0.100	0.140		.116	.118				
C	0.100	0.140		.118	.121				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.260	.260				
L	0.312	0.317		.315	.315				
M	0.235	0.240		.236	.236				
N	0.100	0.140		.111	.112			Miller	ML-01
O	0.540	0.560		.550	.550			Ucrn	ML-7
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Q	3.715	3.725		3.718	3.718				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.628	1.628				
V	1.362	1.372		1.365	1.365				
W	0.316	0.321		.317	.317				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585	DT8695 A/B	1.573	1.573				
Z	0.178	0.198		.188	.188			Rad-gage	REF
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>Ucrn</i>
Date: 10/11/25

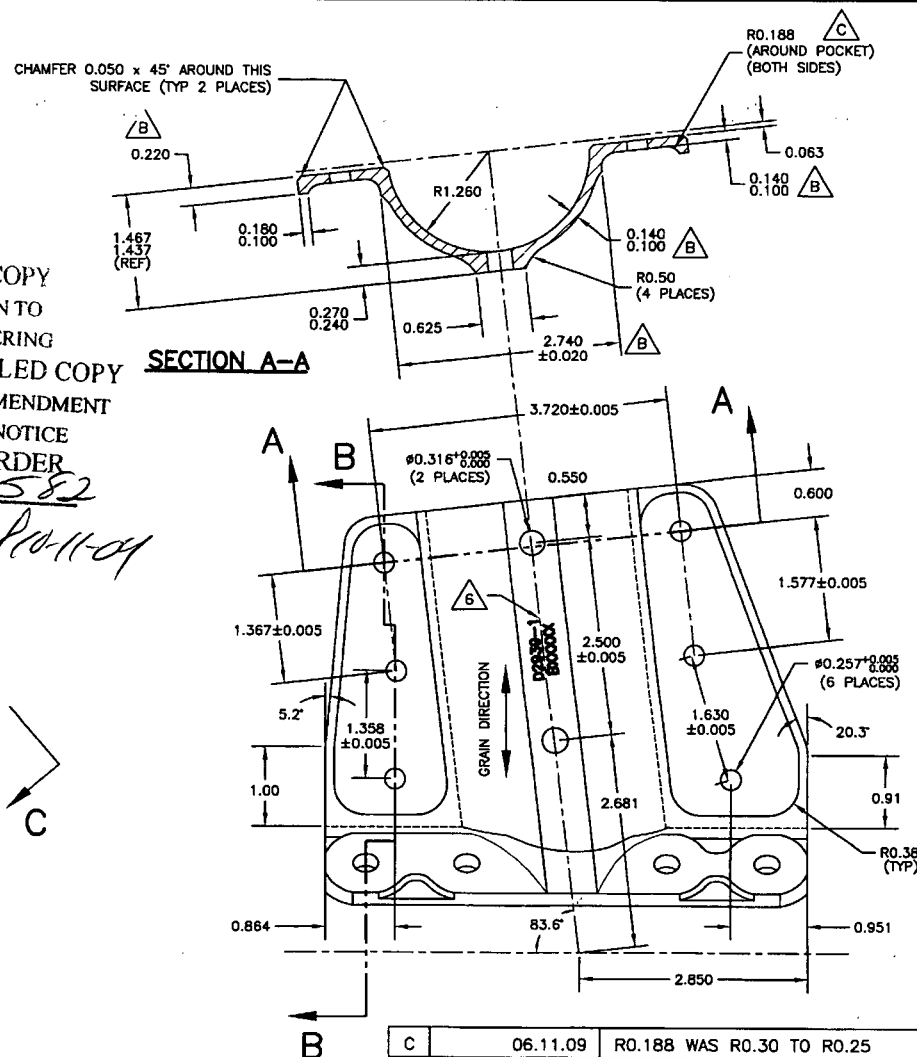
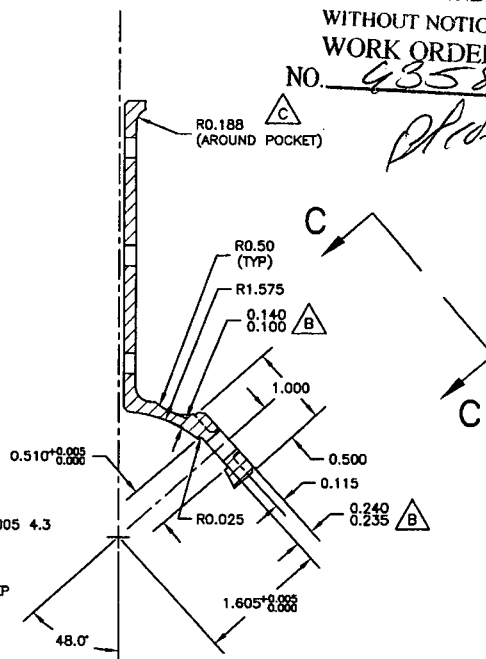
Audited by: <i>H.N</i>
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C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

REV. C
SHEET 1 OF 1
SCALE
2:3

W/O:		WORK ORDER CHANGES					
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